

# Work Order ID 103946

\*103946\*

Page 1

July:08-13 11:39:44 AM

Item ID: D3119-041 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Cover Assembly  
 Start Date: 7/08/13 Start Qty: 2.00 \*2\* Cust-Item ID:  
 Required Date: 7/15/13 Req'd Qty: 2.00 \*2\* Customer:  
 Reference:

Approvals: Process Plan: OK Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3119	Rev B

100 PURCHASING 0.00  
 \*100\*  
 Purchasing Memo 0.00  
 Purchasing Issue P/O: 20459 D3119-041 Cover Assembly as per Dwg  
 D3119 Supplier: Delastek Material: Cream Kydex 100, 0.060 thick Material  
 release note required

110 Receive & Inspect for Damage & Mat'l Certs 0.00  
 \*110\*  
 Packaging Memo 0.00  
 Packaging Ensure Material Release Note is attached

120 QC6- Inspect dimensions to drawing 0.00  
 \*120\*  
 QC Memo 0.00  
 Quality Control

PS 13-07-1

2X SP 13-11-13

Shp  
Blubs

2

Work Order ID 103946

\*103946\*

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July-08-13 11:39:45 AM

Item ID: D3119-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Cover Assembly  
 Start Date: 7/08/13 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 7/15/13 Req'd Qty: 2.00 \*2\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location	0.00							DAS 26 9-89
*130*									
Packaging	Memo	0.00							
Packaging									13-11-14.
140	QC21- Final Inspection - Work Order Release	0.00							
*140*									13/11/18
QC	Memo	0.00							
Quality Control									mf 13-11-13

# Picklist Print

July-08-13 11:39:44 AM

Page 1

Work Order ID: 103946

Parent Item: D3119-041

Start Date: 7/08/13

Required Date: 7/15/13

Parent Item Name: Cover Assembly

Start Qty: 2.00

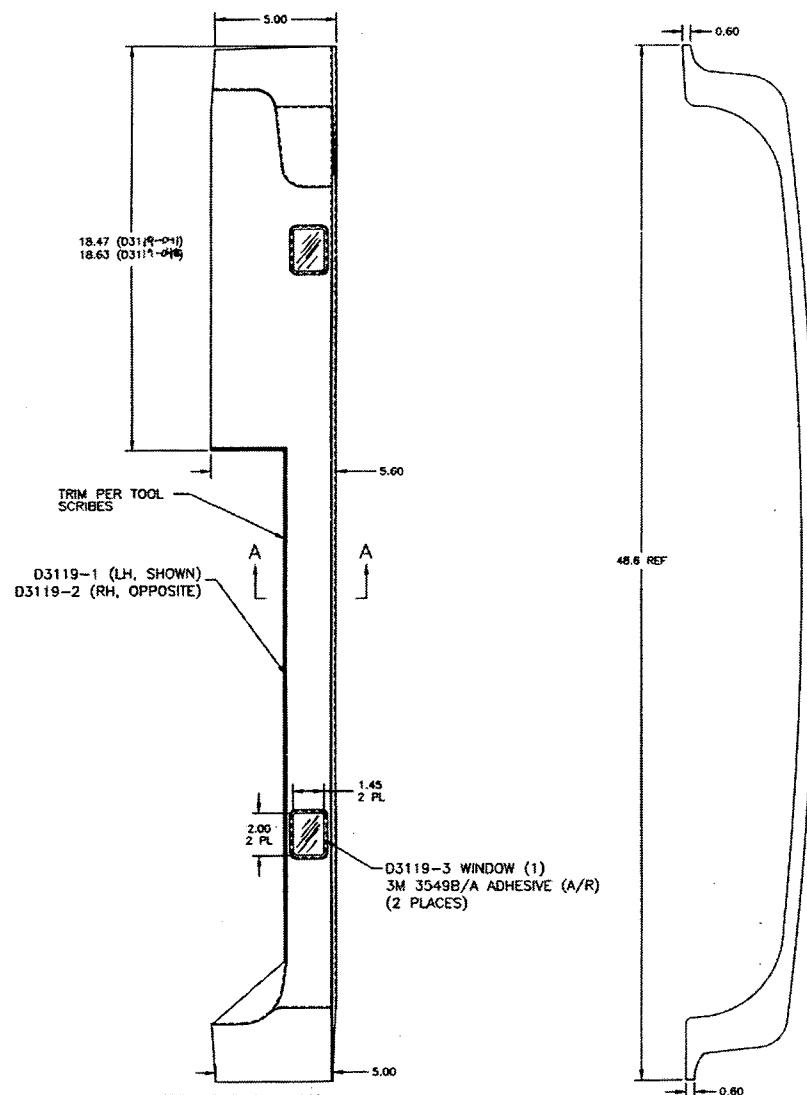
Required Qty: 2.00

Comments: IPP: A03.02.24New IssueKJ/RF

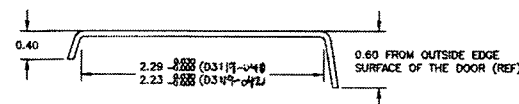
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3119-041P Cover Assembly		Purchased	No			110	Each	0.0000	1	2 <sup>2</sup>		8-13-11-13	



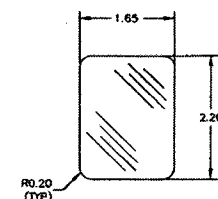
RELEASED  
04.11.17



**D3119-041 COVER ASSEMBLY, LH**  
(SHOWN, REPLACES PREMIER P/N B30-23000-29)  
**D3119-042 COVER ASSEMBLY, RH**  
(OPPOSITE, REPLACES PREMIER P/N B30-23000-30)



**SECTION A-A**



**D3119-3 WINDOW**

*elo*  
*103946*

**D3119-1 COVER, LH (SHOWN, REPLACES PREMIER P/N B30-23000-219)**

- 1) MAKE FROM TOOL B30-23000-219T
- 2) MATERIAL: CREAM KYDEX 100, 0.060 THICK

**D3119-2 COVER, RH (OPPOSITE, REPLACES PREMIER P/N B30-23000-220)**

- 3) MAKE FROM TOOL B30-23000-220T
- 4) MATERIAL: CREAM KYDEX 100, 0.060 THICK

**D3119-3 WINDOW (REPLACES PREMIER P/N B30-23000-221)**

- 5) MATERIAL: LEXAN, 0.060 THICK

**GENERAL NOTES**

- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

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OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

B	04.11.17	RE-DESIGN
A	02.04.15	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3119
DATE	04.11.17	TITLE COVER ASSEMBLY
		REV. B SHEET 1 OF 1 SCALE NTS



DELASTEK Inc.  
2699 5e Avenue  
Local 14,  
Grand-Mère, Québec G9T 2P7  
Canada  
Tel.: (819) 533-5788  
Fax: (819) 533-3494

# PACKING SLI CERTIFICATE OF COMPLIANCE

Invoice No.	49774
Customer No.	DART US

## Bill To

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone : 613-632-5200  
Contact : Linda Lacelle

## Ship To

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone : 613-632-5200  
Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
11-11-2013	25-10-2013	24003	Chantal Lavoie	20459.	Net 30 days USA
Ship Via	F.O.B.	Salesperson	GST/PST		
Purolator collect	Point de départ	Mathieu Doucet, ext.690			
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
2	0	2	DKC135-0001	Line 1 D3119-041 Cover Assy Dwg Rév.: B	U of M: C
				Lot # 54825	

SEP 13-11-13

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by: Mathieu Doucet  
Quality department AQ

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Lundi, 2013-08-12 14:54:13  
Utilisateur: Mario Chantal

Feuille de Procédé

4 / ASAP.



Client : DART US DART AEROSPACE	Nom Dessin : COVER ASSY
Numéro Job : 54825	Numéro Article : DKC135-0001
Numéro : 4138	Numéro Dessin : D3119
Numéro B.A. :	Projet Numéro : DKC135
Cette fois : 2013-08-12 No. :	Révision dessin : B
Prsht Rev. : NC	Matériel : Kydex 100 beige .060" Thk
Prem. fois : - -	Date Dûe : 2013-07-18
Job précédente : 48104	Qté: 2 Ud UNITE
Écrit par :	2013-09-13
Vérifié & Approuvé par :	
Commentaires :	



N° de pièce Dart Aerospace: D3119-041  
N° de pièce Delastek Aeronautique: DKA359-0005  
N° de pièce Delastek Composites: DKC135-0001

Feuille de procédé Rév.: 01 Changer la taille du matériel au thermoformage 16" x 62" x 0.60 Thk modifié pour 23" x 68" x 0.60 Thk.

Produit additionnel

Numéro Job:



# Séq.:	Machine ou	Description :
---------	------------	---------------

1.0	AMB0208	Kydex 100 cream 0.060"thick # 72005
-----	---------	-------------------------------------

Comment Qty.: 0.36 FEUILLE(s)/Unit Total : 0.72 FEUILLE(s)

Kydex 100 cream 0.060"thick

N° de Lot: 1-43081-1

2.0	SORTIE MATÉRIEL	Sortir le matériel
-----	-----------------	--------------------



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Sortir le matériel du magasin

Date: 24/10/13

Sceau :



3.0	THERMOFORMAGE	Thermoformage / Découpe primaire
-----	---------------	----------------------------------



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Thermoformage des pièces.

Monter le set-up du moule de thermoformage N° DKG 359-504 sur le thermoformeur 4' x 8'.

Tailler le matériel selon les dimensions requises :  
23" x 68" x .060" Thk.

Thermoformer la pièce B30-23000-219.

Date: Lundi, 2013-08-12 14:54:13  
Utilisateur: Mario Chantal

## Feuille de Procédé

Client: DART US DART AEROSPACE  
Numéro Job: 54825


Nom Dessin: COVER ASSY  
Numéro DKC135-0001


Numéro Job:



# Séq.: Machine ou Opération: Description:

Autocontrôle de fabrication. (Visuel et épaisseur)

Quantité: 1 Date: 24/10/13 Sceau: 

Quantité: 1 Date: 24/10/13 Sceau: 

4.0 TRIMAGE

Trimage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs


Trimage de finition

Faire le découpage primaire sur la scie à ruban.

Faire le trimmage de la pièce selon la ligne tracée sur le moule (elle doit apparaître sur la pièce) et selon le dessin page 21 (Pour les trous).

Autocontrôle de fabrication. (Visuel et selon le moule)

Déburrer.

Quantité: 2 Date: 4-11-13 Sceau: 

Quantité: 1 Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

5.0 AMB0209

Lexan 9034 0.060" thickness

Comment Qty.: 0.000 FEUILLE(s)/Unit Total: 0.000 FEUILLE(s)

Lexan 9034 0.060" thickness

N° de Lot L-8863-1

6.0 TRIMAGE

Trimage




Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Taillage du matériel.

Sur la banc scie, tailler les B30-2300-221 selon les dimensions du dessins (1.65" x 2.20") et faire des rayons de .20" au quatre coins.

Ébavurer.

Autocontrôle de fabrication. (Visuel et selon le dessin)










Quantité: 2 Date: 4-11-13 Sceau: 

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

Date: Lundi, 2013-08-12 14:54:13

Utilisateur: Mario Chantal


## Feuille de Procédé



<b>Cliant:</b> DART US DART AEROSPACE	<b>Nom Dessin:</b> COVER ASSY	
<b>Numéro Job:</b> 54825	<b>Numéro:</b> DKC135-0001	
Numéro Job: 		
<b># Séq.:</b>	<b>Machine ou Opération:</b>	<b>Description :</b>
7.0	AAC0562	3549 B/A adhesive kit 2oz.
<b>Comment</b> Qty.: 0.00 UNITE(s)/Unit Total: 0.00 UNITE(s)		
3549 B/A adhesive kit 2oz. N° de Lot: <u>1-37924-1</u>		
8.0	PRÉPARATION.	Préparation du matériel
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs		
Faire le mélange de l'adhésif 3549 B/A selon les instructions inscrites sur le contenant.		
Date: <u>4-11-13</u> Sceau: 		
9.0	ASSEMBLAGE	Assemblage mécanique
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
Assemblage général des pièces		
Assembler les deux B30-23000-221 Window sur le B30-23000-219 à l'aide de l'adhésif 3549 B/A et laisser sécher pendant 16 heures.		
Autocontrôle de fabrication. (Assemblage)		
Quantité: <u>2</u> Date: <u>4-11-13</u> Sceau: 		
Quantité: _____ Date: _____ Sceau: _____		
10.0	INSPECTION	Inspection générale
 		
<b>Comment</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
Faire l'inspection de la pièce selon le dessin.		
Quantité: _____ Date: _____ Sceau: _____		
Quantité: _____ Date: _____ Sceau: _____		



Date: Lundi, 2013-08-12 14:54:13  
Utilisateur: Mario Chantal

## Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	COVER ASSY
Numéro Job:	54825	Numéro	DKC135-0001
Numéro Job:			

# Séq.:	Machine ou Opération:	Description :
11.0	IDENTIFICATION	Identification des pièces
		

Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Identification des pièces. *n'importe où sur le côté NON-TEXTURE*

Faire l'identification : N° de pièce : D3119-041

Date de fabrication : *08-11-13*



N° de Work Order: *54825*

Sceau d'inspection

Autocontrôle de fabrication. (Visuel de l'identification)

Quantité : *2* Date *08-11-13* Sceau : *4493 LR*

Quantité : \_\_\_\_\_ Date : \_\_\_\_\_ Sceau : \_\_\_\_\_

12.0	EMBAL / ENTREPO	Emballage & Entreposage
		

Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Emballer et entreposer les pièces selon IG 0057.

Quantité : *2* Date : *10/11/13* Sceau : *44518m*

Insp.   *8 nov. 13*



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO20459**

Purchase Order Date 7/8/2013

PO Print Date 9/5/2013

Page Number 1 of 1

Order From :

DELASTEK INC  
2699 SE AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7  
CA

VU-DEL003

Ship To : DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**RECEIVED**  
6/13/2013

*REVISED*

Contact Name  
Vendor Phone 819 533 5788  
  
Ship To Contact  
Ship To Phone  
Ship Via: FedEx PI collect  
Ship Acct:

Buyer  
Customer POID  
Customer Tax # 10127-2607  
Terms Net 30  
Currency USD  
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price
1	D3119-041P As per DWG D3119 REV B B103946	Cover Assembly	9/13/2013 Yes 9/13/2013		2.00 Each	\$465.00

*8813-11-13*

Line Total:

PO Total:

*u c2*

Note: Pricing listed above is as per contract agreement between Dart Aerospace and the respective manufacturer.  
No substitution or deviation without consent.  
Certificate of Conformity or Material Certification required - YES NO  
PST# 6122-5207

Change Nbr:

4

Change Date: 9/5/2013